

Date: Thursday, 06/11/2008 2:31:56 PM
 User: Julie Dawson

Process Sheet

| | |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : OUTER AFT SADDLE |
| Job Number : 43249 | |
| Estimate Number : 11080 | |
| P.O. Number : | Part Number : D5955 |
| This Issue : 06/11/2008 S.O. No. : | Drawing Number : D5955 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : MACHINED PARTS | Drawing Revision : B |
| Previous Run : 39795 | Material : |
| Written By : | Due Date : 27/11/2008 Qty: 8 Um: Each |
| Checked & Approved By : <u>JLD 08.11.08</u> | |
| Comment : Est Rev:E Re-Format 05-11-29 JLM | |
| Est Rev:F ecn826 06.12.06 ec | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----------|---------------|
| 1.0 | D6101013 | Saddle Billet |
|-----|----------|---------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

D6101-013 (7075-T7351)

Size 2.50" x 10.10" X 8.25" (Grain along 10.10")

Batch: ~~88~~ D38696

J.F. 08/11/12 (8)

| | | |
|-----|-------|--------------------------------|
| 2.0 | HAAS3 | HAAS CNC VERTICAL MACHINING #3 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5955, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

M/J.F. 08/11/12 (8)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
|-----|-----|------------------------------|



Comment: INSPECT ALL DIM TO DIM SHEET

M/J.F. 08/11/13 (8)

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J.L. 08/11/12 8

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/11/22 (8)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 06/11/2008 2:31:57 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER AFT SADDLE

Job Number: 43249

Part Number: D5955

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 POWDER COATING POWDER COATING



M 109152



(8X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00
322 OF
8:30

M-F 08/11/24

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



W



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-24 (X8)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST. PC 8/11/24 (8)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



08/11/26 (8)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-24

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|--------------------------------------|---------------|---------------------------|
| DART AEROSPACE LTD | | Work Order: 43249 |
| Description: Outer Aft Saddle | | Part Number: D5955 |
| Inspection Dwg: D5955 | Rev: B | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|--------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | | 0.440" | 0.440" | 0.440" | 0.440" | | |
| B | 1.745 | 1.755 | | 1.750" | 1.750" | 1.750" | 1.750" | | |
| C | 5.245 | 5.255 | | 5.247" | 5.247" | 5.249" | 5.249" | | |
| D | 6.995 | 7.005 | | 6.996" | 6.997" | 6.999" | 7.000" | | |
| E | 5.240 | 5.260 | | 5.250" | 5.250" | 5.250" | 5.250" | | |
| F | 4.745 | 4.755 | | 4.749" | 4.749" | 4.749" | 4.749" | | |
| G | 0.315 | 0.322 | | 0.320" | 0.320" | 0.320" | 0.320" | | |
| H | 1.522 | 1.532 | | 1.526" | 1.526" | 1.526" | 1.526" | | |
| I | 3.048 | 3.058 | | 3.054" | 3.054" | 3.054" | 3.054" | | |
| J | 4.575 | 4.585 | | 4.580" | 4.580" | 4.580" | 4.580" | | |
| K | 0.315 | 0.322 | | 0.320" | 0.320" | 0.320" | 0.320" | | |
| L | 0.495 | 0.505 | | 0.500" | 0.500" | 0.500" | 0.500" | | |
| M | 0.490 | 0.510 | | 0.499" | 0.500" | 0.500" | 0.500" | | |
| N | 1.865 | 1.885 | | 1.875" | 1.875" | 1.875" | 1.875" | | |
| O | 7.990 | 8.010 | | 8.000" | 8.000" | 8.000" | 8.000" | | |
| P | 2.240 | 2.260 | | 2.250" | 2.250" | 2.250" | 2.250" | | |
| Q | 0.307 | 0.312 | | 0.311" | 0.311" | 0.311" | 0.311" | | |
| R | 0.760 | 0.765 | | 0.760" | 0.760" | 0.760" | 0.760" | | |
| S | 0.490 | 0.510 | | 0.508" | 0.504" | 0.501" | 0.500" | | |
| T | 1.625 | 1.645 | | 1.635" | 1.635" | 1.636" | 1.635" | | |
| U | 2.000 | 2.020 | | 2.007" | 2.007" | 2.007" | 2.007" | | |
| V | 0.023 | 0.043 | | 0.033" | 0.033" | 0.033" | 0.033" | | |
| W | | | | | | | | | |
| X | | | | | | | | | |
| Y | | | | | | | | | |
| Z | | | | | | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|---------------------|
| Measured by: | J.F. |
| Date: | 08/11/12 / 08/11/13 |

| | |
|-------------|----------|
| Audited by: | J.L. |
| Date: | 08/11/12 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | 99.04.19 | New Issue | RF | |
| B | 02.12.13 | Reformat; Added Dim. T-U & DT8682, DT8686 | KJ/RF | |
| C | 06.11.20 | Added dimension V | KJ/JLM | |
| D | 06.12.06 | Dimensions L,N,P revised | KJ/EC | |
| E | 07.06.15 | Dimension G revised | KJ/JLM | |
| F | 08.04.21 | Dimension E revised | KJ/DD | |
| G | 08.08.05 | Dimension K revised | KJ/DD | |

| | | |
|--------------------------------------|---------------|---------------------------|
| DART AEROSPACE LTD | | Work Order: 43249 |
| Description: Outer Aft Saddle | | Part Number: D5955 |
| Inspection Dwg: D5955 | Rev: B | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|-------|-------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | | .440 | .440 | .440 | .440 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 5.245 | 5.255 | | 5.250 | 5.250 | 5.250 | 5.250 | | |
| D | 6.995 | 7.005 | | 7.000 | 7.000 | 7.000 | 7.000 | | |
| E | 5.240 | 5.260 | | 5.248 | 5.249 | 5.248 | 5.248 | | |
| F | 4.745 | 4.755 | | 4.746 | 4.749 | 4.748 | 4.748 | | |
| G | 0.315 | 0.322 | | .321 | .321 | .321 | .321 | | |
| H | 1.522 | 1.532 | | 1.526 | 1.527 | 1.524 | 1.526 | | |
| I | 3.048 | 3.058 | | 3.052 | 3.056 | 3.056 | 3.056 | | |
| J | 4.575 | 4.585 | | 4.579 | 4.581 | 4.580 | 4.580 | | |
| K | 0.315 | 0.322 | | .321 | .321 | .321 | .321 | | |
| L | 0.495 | 0.505 | | .500 | .500 | .500 | .500 | | |
| M | 0.490 | 0.510 | | .500 | .499 | .500 | .499 | | |
| N | 1.865 | 1.885 | | 1.885 | 1.883 | 1.883 | 1.883 | | |
| O | 7.990 | 8.010 | | 8.000 | 8.000 | 8.000 | 8.000 | | |
| P | 2.240 | 2.260 | | 2.256 | 2.256 | 2.256 | 2.256 | | |
| Q | 0.307 | 0.312 | | .311 | .311 | .311 | .311 | | |
| R | 0.760 | 0.765 | | .760 | .760 | .760 | .760 | | |
| S | 0.490 | 0.510 | | .501 | .500 | .500 | .500 | | |
| T | 1.625 | 1.645 | | 1.635 | 1.633 | 1.635 | 1.635 | | |
| U | 2.000 | 2.020 | | 2.010 | 2.010 | 2.010 | 2.010 | | |
| V | 0.023 | 0.043 | | | | | | | |
| W | | | | | | | | | |
| X | | | | | | | | | |
| Y | | | | | | | | | |
| Z | | | | | | | | | |
| AA | | | | | | | | | |
| AB | | | | | | | | | |
| AC | | | | | | | | | |
| AD | | | | | | | | | |
| AE | | | | | | | | | |
| AF | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

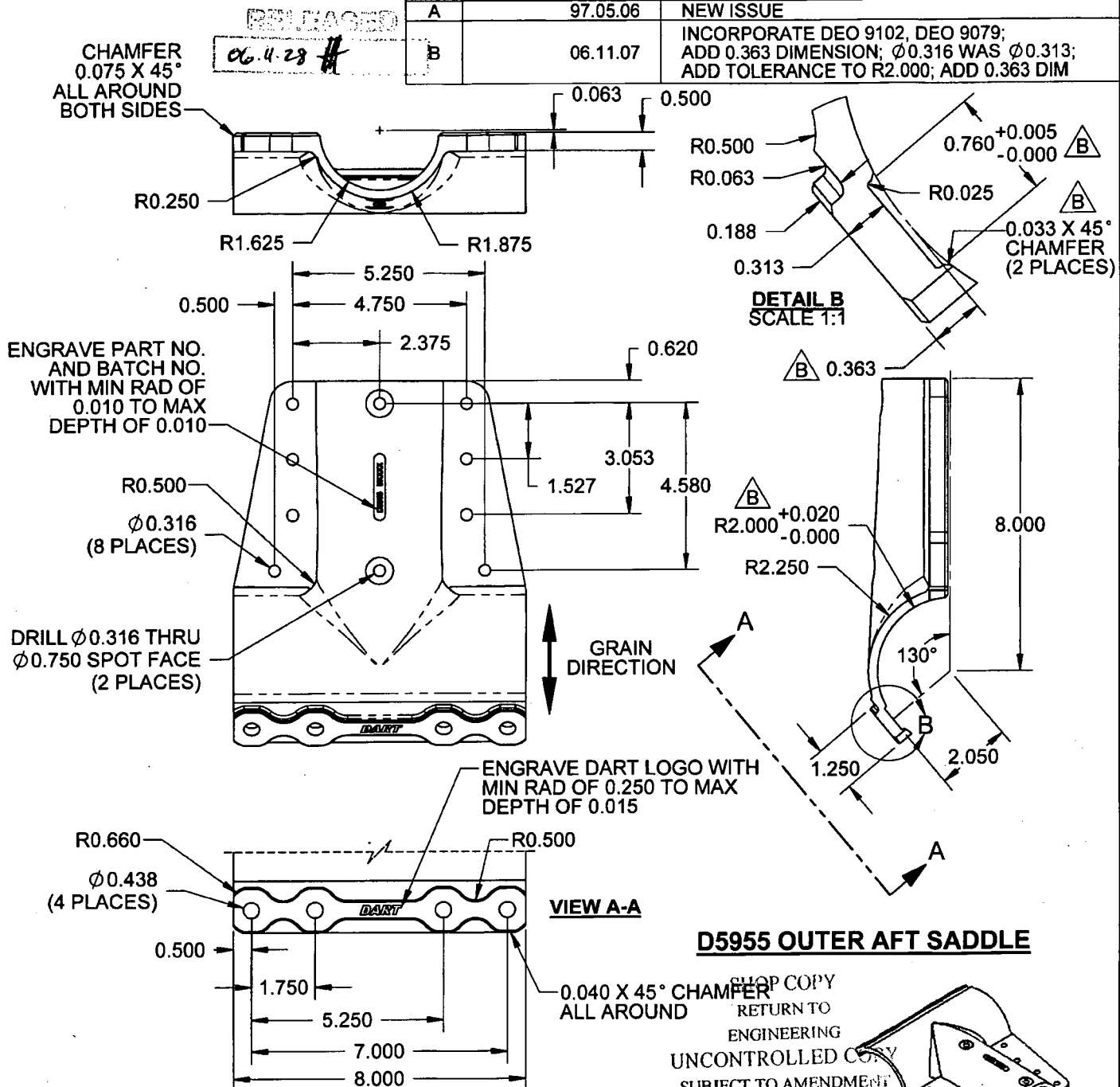
| |
|------------------------|
| Measured by: <i>GR</i> |
| Date: 08/11/13 |

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|-----------------------|
| Audited by: <i>JI</i> |
| Date: 08/11/21 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | 99.04.19 | New Issue | RF | |
| B | 02.12.13 | Reformat; Added Dim. T-U & DT8682, DT8686 | KJ/RF | |
| C | 06.11.20 | Added dimension V | KJ/JLM | |
| D | 06.12.06 | Dimensions L,N,P revised | KJ/EC | |
| E | 07.06.15 | Dimension G revised | KJ/JLM | |
| F | 08.04.21 | Dimension E revised | KJ/DD | |
| G | 08.08.05 | Dimension K revised | KJ/DD | |

DART

| | | | |
|-------------------------|--|--|------------------------|
| DESIGN BW | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED LE | APPROVED [Signature] | DRAWING NO. D5955 | REV. B SHEET 1 OF 1 |
| DATE 06.11.07 | TITLE OUTER AFT SADDLE SCALE 1:4 | | |
| REV A | DATE 97.05.06 | DESCRIPTION NEW ISSUE | |
| REV B | DATE 06.11.07 | DESCRIPTION INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM | |

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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